

5/46

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	24684
<b>Description: Bracket</b>	<b>Part Number:</b>	D3146-1
<b>Dwg: D3146 Rev. A</b>	<b>Qty:</b>	5
		Page 1 of 1

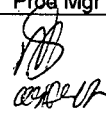
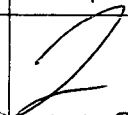
Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	JL	05.10.26	5
2	MV	Cut blanks: 4.500" x 1.250" x 3.100" long Bar Material: 6061-T6/T651 (QQ-A-200/8) 1.250" thick (M6061T6B1.250x04.500) Identify for D3146-1 Batch: 117655	J.L	05.10.29	5
3	MV	Machine as per Folio FA419 and Dwg D3146 Identify as D3146-1	J.L	05.10.30	5
4	QC2	Inspect parts as they come off the CNC machine	J.L	05.10.30	5
5	QC8	Second check	J.L	05.10.30	5
6A	MV	Deburr and Tumble	J.L	05.10.30	5
7	FP	Chemical Conversion Coat as per QSI 005 4.1	SAD	05/11/19	5
8	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3	J.L	05.11.24	5
9	QC3	Inspect Powder Coat	C.L	05.11.25	5
10 66	QC5	Inspect work to Step 9	J.L	05.11.27	5
11	ST	Identify and Stock in Spacedoor Cell	J.L	05.11.28	5
12	AC	Cost / part	J.L	05.11.28	5
13	DC	Close W/O Inspect Level 21	J.L	05.11.28	5


Rev	Date	Change	Revised By	Approved
A	04.04.28	New issue	KJ/JLM	

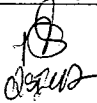

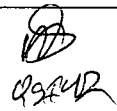
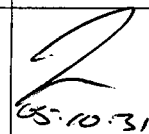
RELEASED

04.04.29

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
05-11-28	10	QCS should be after step 6 for inspection of cleaning, and work up to step 6.  Permanent Change.					 05-11-28

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:  Date: 05/11/28  
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
05-10-30	3	- 1 part came out of vice - 2 parts scrap dimension .125 is under tolerance		- scrap & replace	J.L 05.11.28	 05-10-31		 05-10-31

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	24684
<b>Description:</b> Bracket		<b>Part Number:</b>	D3146-1
<b>Inspection Dwg:</b> D3146	<b>Rev:</b> A	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.000	+/-0.010	3.003	✓			
2.000	+/-0.010	2.001	✓			
0.230	+/-0.010	.233	✓			
0.425	+/-0.010	.425	✓			
3.420	+/-0.010	3.421	✓			
2.535	+/-0.010	2.536	✓			
0.221	+/-0.010	.221	✓			
0.391	+/-0.010	.385	✓			
0.221	+/-0.010	.221	✓			
0.850	+/-0.010	.850	✓			
R0.350	+/-0.010	.350	✓			
0.850	+/-0.010	.850	✓			
0.221	+/-0.010	.221	✓			
0.491	+/-0.010	.485	✓			
0.125	+/-0.010	.128	✓			
1.025	+/-0.010	1.019	✓			
R0.375	+/-0.010	.375	✓			
28°	+/-0.1°	28°	✓			
0.276	+/-0.010	.280	✓			
0.925	+/-0.010	.930	✓			
R0.125	+/-0.010	.125	✓			
4.345	+/-0.010	4.349	✓			
0.125	+/-0.010	.129	✓			
93°	+/-0.1°	93°	✓			
R0.125	+/-0.010	.125	✓			
Grain Direction	N/A					

<b>Measured by:</b> J.L	<b>Audited by:</b> JML	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 05.10.29	<b>Date:</b> 05/10/29	<b>Date:</b>	N/A

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A		New Issue	KJ/JLM	

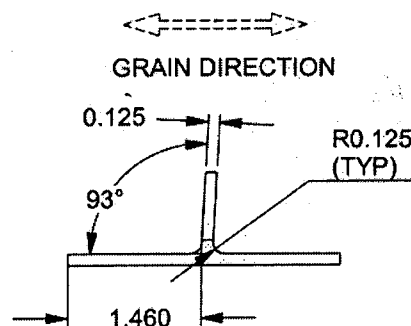
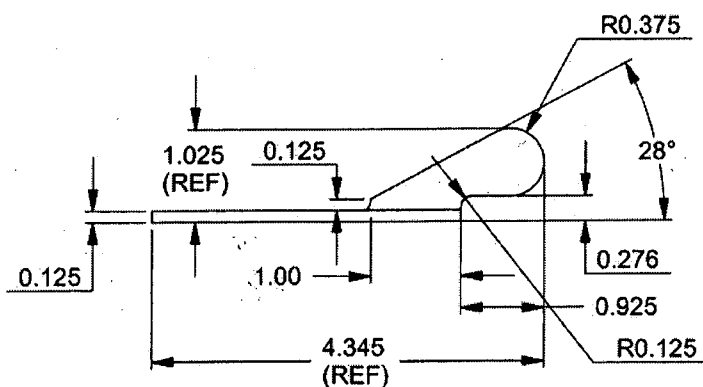
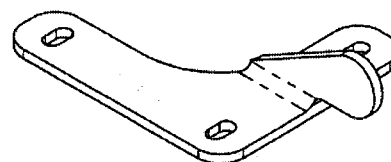
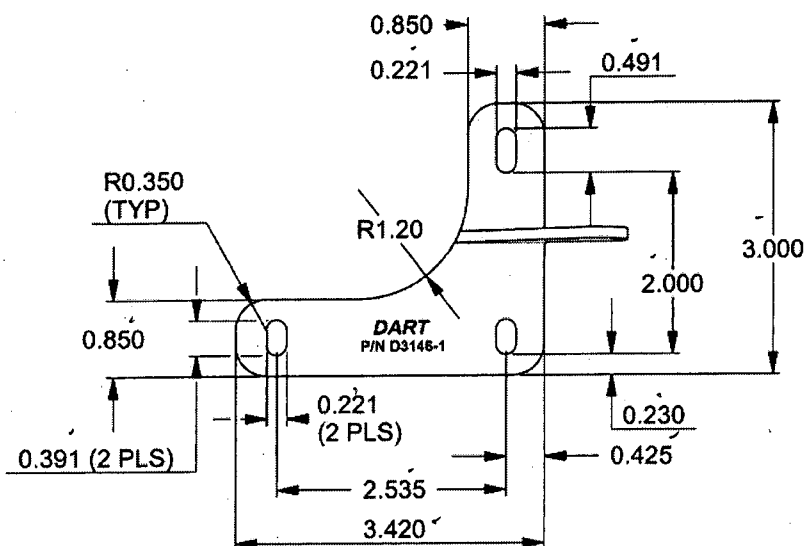
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10/04/00 27



DESIGN #	DRAWN BY RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3146	REV. A SHEET 1 OF 1
DATE 02.04.25	TITLE BRACKET		SCALE 1:2
A	02.04.25	NEW ISSUE	

RELEASED  
02.05.27



D3146-1 BRACKET SHOWN. REPLACES PREMIER P/N B30-23000-27  
(D3146-2 BRACKET OPPOSITE. REPLACES PREMIER P/N B30-23000-28)

**NOTES:**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR (REF. DART SPEC. M6061T6B)
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3  
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N AND LOGO AS SHOWN

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24684

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Oct 25, 2005  
04:04 pm

Work Order No : 0024684  
Project Name : D3146-1  
Project For : WK546  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3146-1  
Description : Hinge Bracket  
Manufactured : Yes  
Amount Req'd : 5  
Amount Done : 0  
Start Date : 10-25-05  
Est Finish Date : 11-15-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Nov 08, 2005  
12:44 pm

Work Order No : 0024684  
Project Name : D3146-1  
Project For : WK546  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3146-1  
Description : Hinge Bracket  
Manufactured : Yes  
Amount Req'd : 5  
Amount Done : 0  
Start Date : 10-25-05  
Est Finish Date : 11-15-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Margin : 0.000%  
Actual Margin : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	16.50	100.00		
Production Cost :	0.00	287.14	100.00	0.00	287.14
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	16.50	100.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	287.14	100.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	287.14			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	( -287.15)

*MUS d/B*  
*u*  
*11-13*

Date: Monday, 14/11/2005 8:12:09 AM  
 User: Alba Panzuto

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: BRACKET
<b>Job Number</b>	: 24684		
<b>Estimate Number</b>	: 10393		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D31461
<b>This Issue</b>	: 14/11/2005	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: D3146 REV A
<b>First Issue</b>	: / /	<b>Project Number</b>	:
<b>Previous Run</b>	:	<b>Drawing Revision</b>	: A
	<b>Type</b> : MACHINED PARTS	<b>Material</b>	:
<b>Written By</b>	:	<b>Due Date</b>	: 30/11/2005
<b>Checked &amp; Approved By</b>	:	<b>Qty:</b>	5
<b>Comment</b>	: Est A04.04.28 New issue KJ/JLM	<b>Um:</b>	Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B1250X04500	6061-T6 Bar 1.25" X 4.5"
2.0	BAND SAW	BAND SAW
<b>Comment:</b> BAND SAW Cut blanks: 4.500" x 1.250" x 3.100" long Bar		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
<b>Comment:</b> HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA419 and Dwg D3146 Identify as D3146-1		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE		
5.0	QC8	SECOND CHECK
<b>Comment:</b> SECOND CHECK		
6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
<b>Comment:</b> SMALL & MEDIUM FAB RESOURCE 1 Deburr and Tumble		
7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
<b>Comment:</b> HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		

Date: Monday, 14/11/2005 8:12:10 AM  
User: Alba Panzuto

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 24684

Part Number: D31461

Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: Inspect work to Step 9

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion

